

# Work Order ID 65788

January 26, 2011 9:02:20 AM



Page 1

Item ID: D3535-21

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 1/26/11 Start Qty: 6.00



Cust Item ID:

Required Date: 1/31/11 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 1/10/12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3535	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessary

B11-1-31



304 . 410

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-1-31

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sulu/71



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
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# Work Order ID 65788

January 26, 2011 9:02:20 AM



Page 3

Item ID: D3535-21

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 1/26/11 Start Qty: 6.00



Cust Item ID:

Required Date: 1/31/11 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: FD18

0.00

Memo

0.00

180



QC

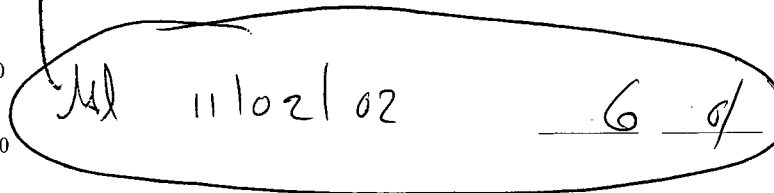
Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00



6 BL 11-02-1

11/02/02  
mr  
11-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

January 26, 2011 9:02:19 AM

Page 1

Work Order ID: 65788

Parent Item: D3535-21

Parent Item Name: Wearshoe



Start Date: 1/26/11

Required Date: 1/31/11

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

182.9000

0.8925

5.636842

11



304/316 .040 Sheet



1811-1-31

Location

Loc Qty

Loc Code

MAT

182.9

115953

32.1

116437

54.8

116623

96

115953



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	65788
<b>Description: Wearshoe</b>		<b>Part Number:</b>	D3535-21
<b>Inspection Dwg: D3535</b>	<b>Rev: B</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.191	X		V B02	
2.000	+/-0.010	2.000	X		V	
2.000	+/-0.010	1.997	X		V	
1.885	+/-0.010	1.890	X		V	
0.300	+/-0.010	.302	X	V	V	
0.300	+/-0.010	.305	X	V	V	
5.450	+/-0.010	5.450	X		T B01	
10.900	+/-0.010	10.900	X		T	
16.350	+/-0.010	16.350	X		T	
21.800	+/-0.010	21.800	X		T	
27.250	+/-0.010	27.250	X		T	
32.700	+/-0.010	32.700	X		T	
6.00	+/-0.030	6.00	X		V	
8.00	+/-0.030	8.00	X		V	
16.00	+/-0.030	16.00	X		V	
24.00	+/-0.030	24.00	X		V	
0.040	+/-0.010	.037	X		V	

<b>Measured by:</b>	B
<b>Date:</b>	11-1-31

<b>Audited by:</b>	S
<b>Date:</b>	11/01/21

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	10.2.02	New Issue	KJ	

W/O:		WORK ORDER CHANGES						
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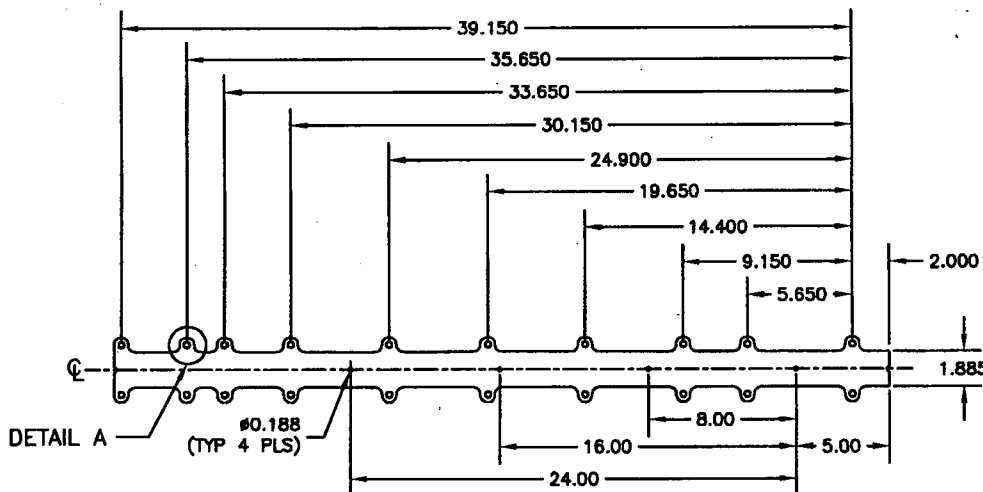
**DART**

RELEASED

07.04.24

C211101124  
W10.65788

DESIGN	DRAWN BY	TITLE	DATE
CB	PH	WEARSHOE	07.04.17
CHECKED	APPROVED	DRAWING NO.	SCALE
		D3535	1:10
REV. B	SHEET 2 OF 7		

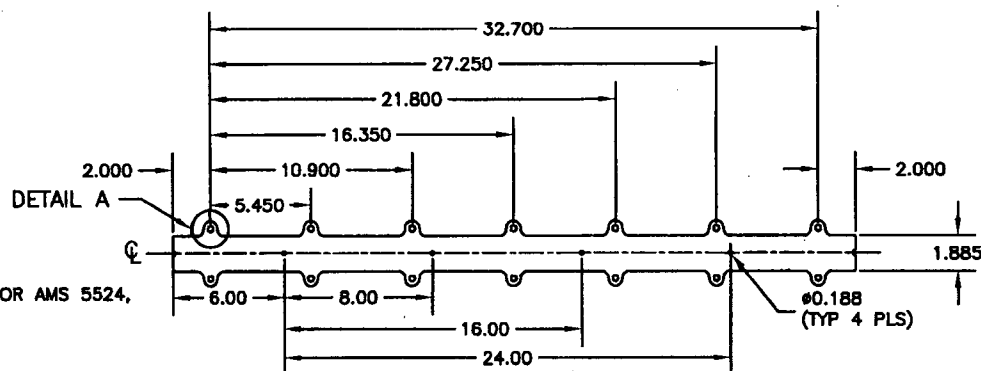


4.50 TO BEND  
LINE (ON FLAT  
PATTERN)

**D3535-15F FLAT PATTERN**

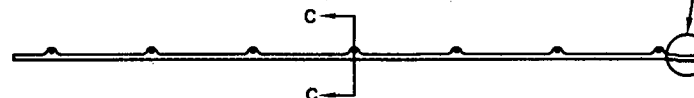
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(REF)

**D3535-15 BEND DETAIL**



**D3535-21F FLAT PATTERN**

DETAIL B



**D3535-21 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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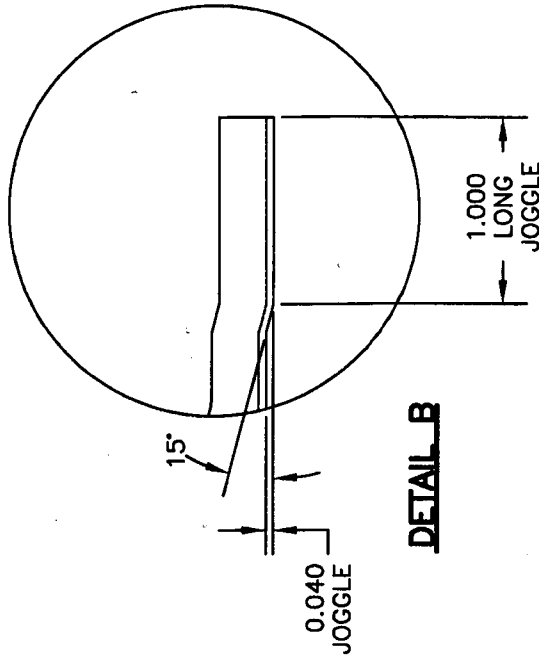
**NOTE:** Date & initial all entries



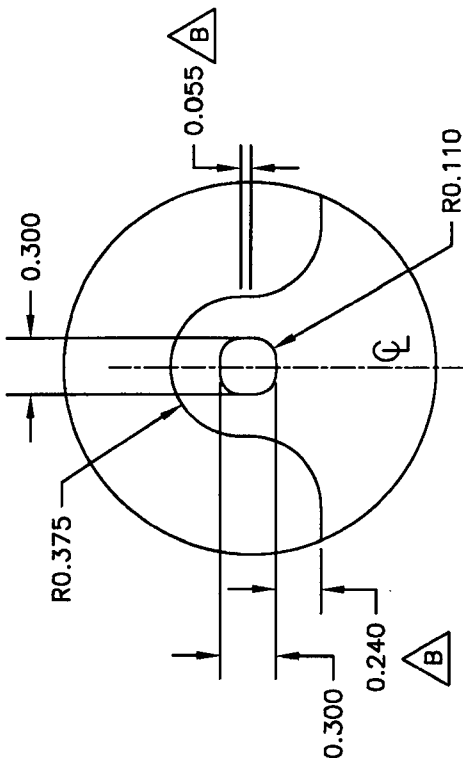
DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED

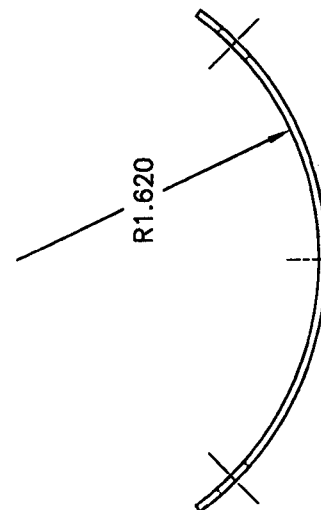
07.04.24



**DETAIL B**



**DETAIL A**



**SECTION C-C**

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